Date: Tuesday, 25/11/2008 9:52:45 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 43724 -1
Estimate Number : 10606
P.O. Number :
This Issue : 25/11/2008 S.O. No. :
Prsht Rev. : NC
First Issue : / / Type : SMALL /MED FAB
Previous Run : 43427
Written By :
Checked & Approved By : JME 08-11-25
Comment : Est: A 05.05.12 New issue KJ/JLM
Est Rev:B Now on Waterjet 06-10-03 JLM

Drawing Name : WEARPLATE
Part Number : D33193
Drawing Number : D3319 REV. B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 02/12/2008 Qty: Split 3 /12 Um: Ea

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025 SHEET .048

Comment: Qty.: 3.4150 sf(s)/Unit Total : 40.9802 sf(s)
1010/1025/A21/6aA SHEET .048" Thick
Batch: 109948 JB 8-11-25

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3319
Dwg Rev: B JB 8-11-25
Prog Rev: B
2-Deburr if necessary JB 8-11-25

(B)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

JB 8-11-25

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK

S 08/11/26 (JB)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

N/A Done at step #2-2
S 08/11/26

ay, 25/11/2008 9:52:45 AM
anie Fauteux

Process Sheet

omer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 43724

Part Number: D33193

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

08/11/26

7.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

08/11/26 (+3)

8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	M109560

8-11-26 X3

9.0	QC10	VISUAL INSPECTION OF GROUND WELDS

Comment: VISUAL INSPECTION OF GROUND WELDS

08/11/26 (3)

10.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

08/11/26 (+3)

11.0	POWDER COATING	POWDER COATING

M109648 (3X)

Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 2:10
OVEN TEMPERATURE: 320 °F
FINISH TIME: 2:40

M. L 08/11/26

12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT

FL 08/11/26 (3)

13.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** WEARPLATE

Job Number: 43724 **Part Number:** D33193

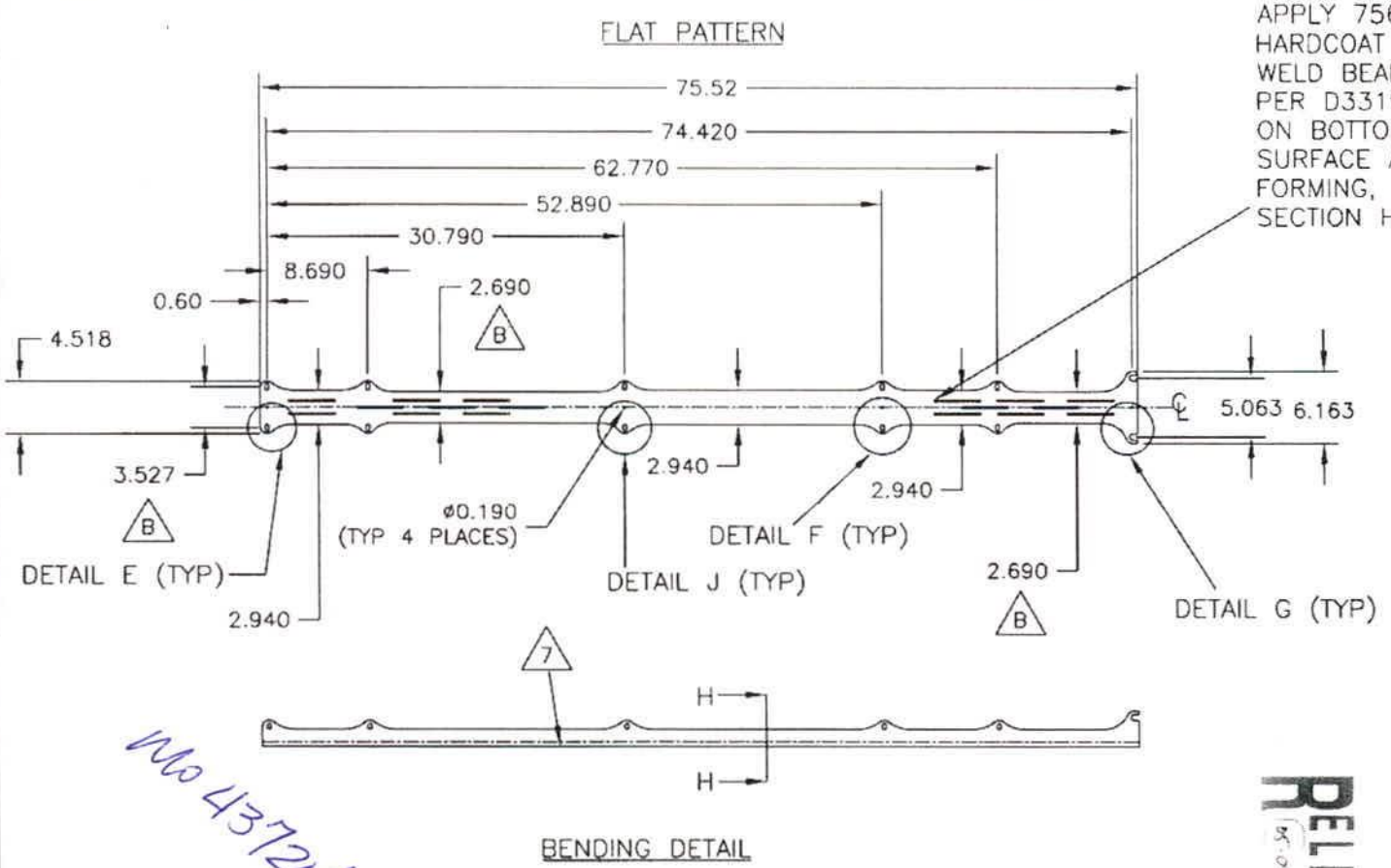
Job Number:

Seq. #:	Machine Or Operation:	Description :
	P/N: D3319-3, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: ST496	SS 08/11/27 (x3)
14.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 08/11/27 MF

Job Completion

MF 08-11-27



BENDING DETAIL

MO 43724

RELEASED

D3319-3 WEARPLATE

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) PART IS SYMMETRICAL ABOUT CENTERLINE
5) ALL DIMENSIONS IN INCHES
6) WELD PER DART QSI 004
7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
		D3319	B
CHECKED	APPROVED		SHEET 2 OF 5
DATE		TITLE	SCALE
05.06.06		WEARPLATE	1:15

DART AEROSPACE LTD	Work Order:	43724
Description: Wearplate	Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	✓			
74.420	+/-0.010	74.420	✓			
62.770	+/-0.010	62.770	✓			
52.890	+/-0.010	52.890	✓			
30.790	+/-0.010	30.790	✓			
8.690	+/-0.010	8.684	✓			
0.60	+/-0.030	.603	✓			
2.690	+/-0.010	2.694	✓			
2.940	+/-0.010	2.946	✓			
3.527	+/-0.010	3.524	✓			
4.518	+/-0.010	4.517	✓			
Ø0.190	+0.005/-0.001	.194	✓			
2.940	+/-0.010	2.946	✓			
2.940	+/-0.010	2.946	✓			
2.690	+/-0.010	2.697	✓			
5.063	+/-0.010	5.064	✓			
6.163	+/-0.010	6.162	✓			
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	.318X.608	✓			
0.048	+/-0.010	.044	✓			

Measured by:	JB
Date:	8-11-25

Audited by:	
Date:	08/14/26

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	